

5/43

66 cut

DART AEROSPACE LTD		Work Order:	24399
Description: Lug		Part Number:	D2230-3
Drawing: D2230 Rev. F		Qty:	300 200

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O		05.10.03	200
2	METAL	Cut D2423 extrusion to 0.82"		05/10/03	68/200
3	HAAS PG	Machine per file D2230-3 Check for crack while loading into the machine	JG	05/10/03	200
4	QC LG	Inspect Level 2 Receive + Inspect for trans. damage	JL	05/11/15	300
5	QC	Inspect Level 5		05/12/13	300
6	METAL	Tumble and deburr rough edges after tumbling if applicable	JL	05/12/14	300
7	METAL	Acid etch and Alodine per QSI 005 4.1	SAD	05/12/28	300
8	QC	Inspect Level 5		05/12/30	300
9	FINISHING	Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3	MM	06/01/10	300
10	QC	Inspect Level 3		06/01/11	300
11	STORES	Identify and stock		06/01/12	293
12	EXPEDITING	Close W/O Job Cost / Part	Luc 16y	06/01/13	293

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Rev	Date	Change	Revised By	Approved
A	97.02.21	New Issue		
B	98.06.01	Re-Format	KB	
C	00.01.27	Re-Format, added level 2 insp., Rev. F (mpp 2022)	EC	
D	00.05.18	Added inspection level 8, and removed P/O for powder coat	EC	

RELEASED

EC 00.05.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

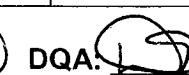
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 06/01/13

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

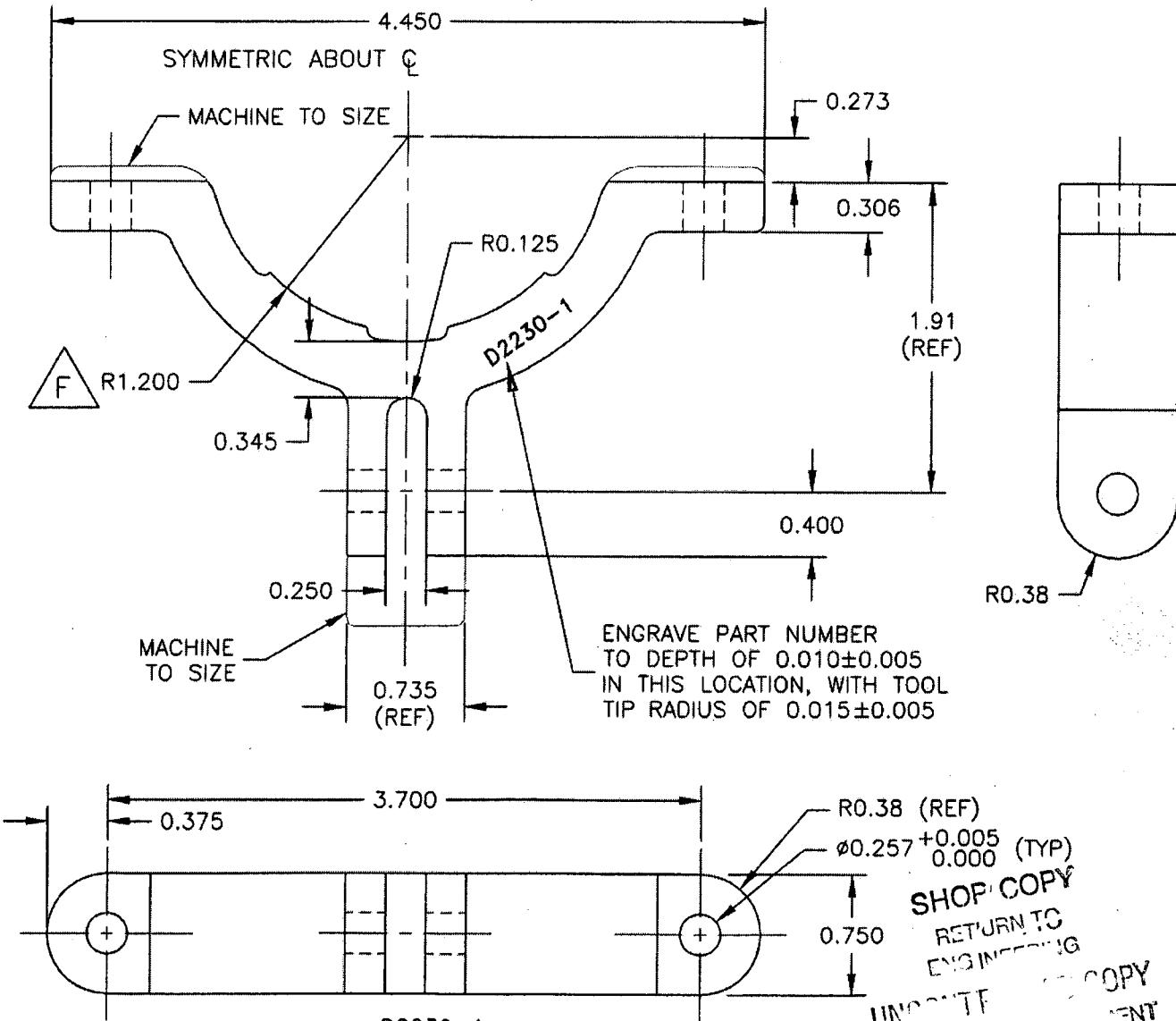
DA

D



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F
DATE		SHEET 1 OF 2
99.12.13		SCALE 1:1
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

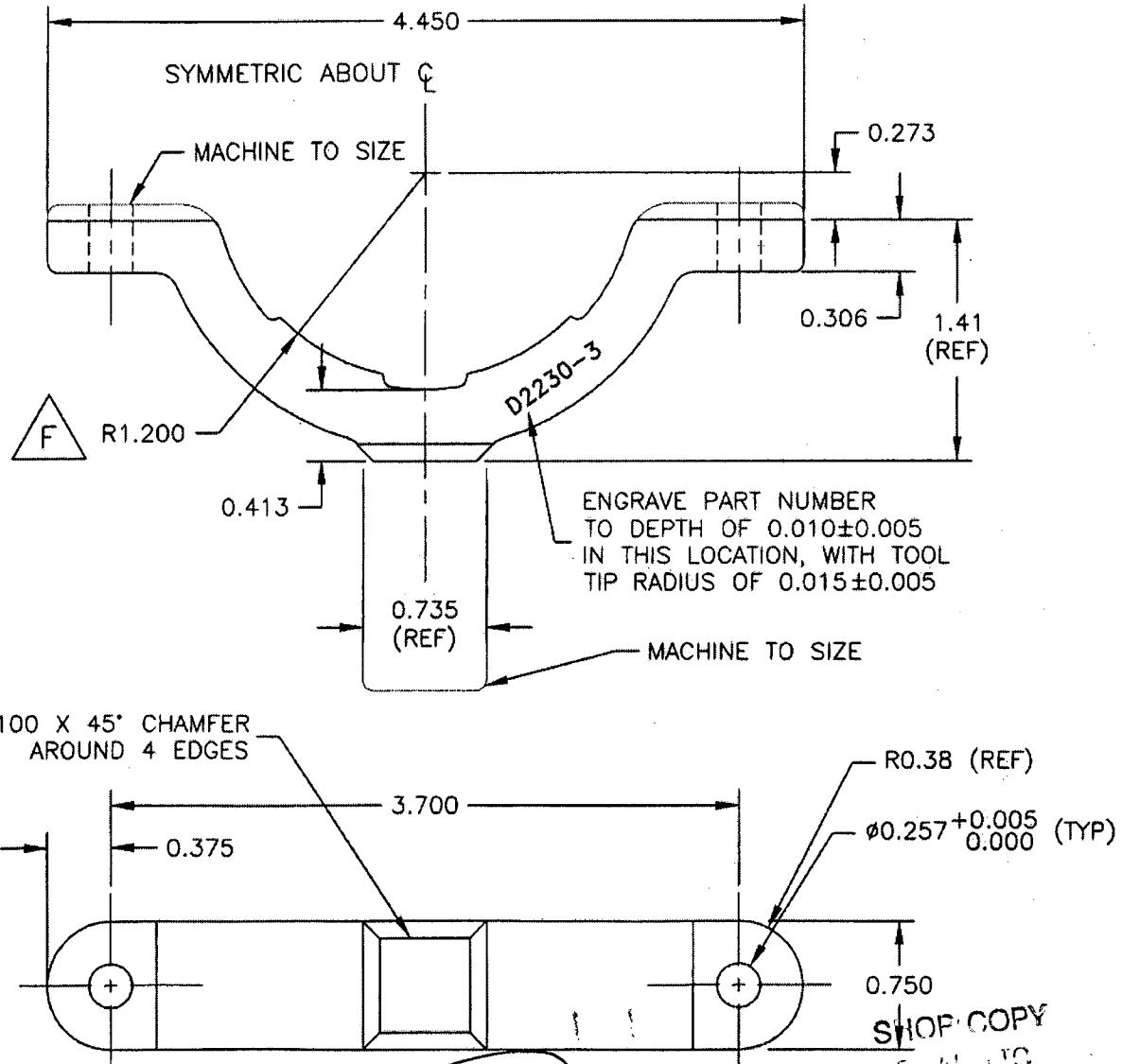
W/C ORDER
24399



1 COPY ISSUED
GP

DESIGN	DRAWN BY	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	GP	DRAWING NO. D2230
DATE			REV. F SHEET 2 OF 2 SCALE 1:1

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

24399

Job Costing Report

Dart Aerospace Ltd.
HawkesburyOct 03, 2005
11:23 am

Work Order No : 0024399
 Project Name : D2230-3
 Project For : WK543
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2230-3
 Description : Mounting Lug
 Manufactured : Yes
 Amount Req'd : 200
 Amount Done : 0
 Start Date : 10-03-05
 Est Finish Date : 10-30-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====		=====	=====		
Burden :	0.00	0.00	0.00		
=====		=====	=====		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00



CERTIFICATE OF COMPLIANCE

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
300	D 2230-3	Mounting Lug	2008788

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shig (Regula) Walt
Shig (Regula) Walt

Vankleek Hill, November 14, 2005

